

IN THE CLAIMS:

Cancel claims 1-20. Add 21-32.

21. (New) A method for producing plastic profiles, in which a first profile is initially produced by extruding a profiled bar through an extruder and molding said profiled bar in a first extrusion die nozzle that is connected to the extruder, whereupon the profiled bar is calibrated in a first calibrating die arranged on a calibrating table and is chilled, whereupon the first calibrating die is separated from the extruder and a second calibrating die is attached in order to produce thereafter a second profile, with cooling water and/or vacuum supply lines being connected to the calibrating die attached to the calibrating table, wherein prior to severing the first calibrating die the second calibrating die is made available on a freely movable second manipulating device in the region of the calibrating table, whereupon the first calibrating die is removed from the calibrating table by a lifting apparatus of the second manipulating device transversally to the direction of extrusion and the second calibrating die is brought to the calibrating table to the docking position by the lifting apparatus for the calibrating die transversally to the direction of extrusion and that upon removal of the first calibrating die from the calibrating table cooling water and/or vacuum supply lines are severed automatically from the first calibrating die and, after transfer to the second calibrating die to the calibrating table to the docking position, are connected automatically to the second calibrating die.

22. (New) A method according to claim 21, wherein the first calibrating die is removed from the calibrating table by a first lifting apparatus of the second manipulating device for the calibrating die and the second calibrating die is brought to the calibrating table to the docking position by a second lifting apparatus of the second manipulating device for the calibrating die.

23. (New) A method according to claim 21, wherein the removal of the first calibrating die from the calibrating table and the delivery of the second calibrating die to the calibrating table occurs from the same longitudinal side of the calibrating table.

24. (New) A method according to claim 21, wherein the removal of the first calibrating die from the calibrating table and the delivery of the second calibrating die to the calibrating table occurs from different longitudinal sides of the calibrating table.

25. (New) An apparatus for manipulating calibrating dies which is configured as a movable first manipulating device, comprising at least one nozzle lifting apparatus for receiving extrusion die nozzles, wherein the calibrating die can be connected to the cooling water and/or vacuum supply lines of the calibrating table by way of an automatic coupling unit.

26. (New) An apparatus according to claim 25, wherein the lifting apparatus for the calibrating die comprises a first lifting arm for receiving a first calibrating die and a second lifting arm for receiving a second calibrating die.

27. (New) An apparatus according to claim 26, wherein the first and second lifting arm of the lifting apparatus for the calibrating die are movable independent from each other.

28. (New) An apparatus according to claim 25, wherein the second manipulating device is provided with a configuration so that it can be docked to the calibrating table and can be fixed there.

29. (New) An apparatus according to claim 25, wherein the second manipulating device comprises at least one displacement unit, preferably with roller or slide bearing, for the calibrating die

30. (New) An apparatus according to claim 25, wherein the second manipulating device is provided with only one lifting device and the changing process is supported by a transversal displacement unit.

31. (New) An apparatus according to claim 25, wherein the transversal displacement unit is arranged between the calibrating die and the mounting frame of the calibrating table, and the calibrating die rests on the transversal displacement unit by vertical lowering of the mounting frame and the cooling water and vacuum supply lines are severed as a result.

32. (New) An apparatus according to claim 25, wherein the first and/or second manipulating device is provided with an automotive configuration.